



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4780-041

Job Sheet 172986



Part No: D4780-041

Job Qty: 8 ea

Part Name: Fwd Cover Mounting Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/23/18

Job Tracking No:

Due Date: 3/5/18

Created By: Logan David

Type: Stock

Description:

Note: DWG REV A IPP REV A 13.03.13 NEW ISSUE DD VERF:JLM

Ship Via:

Ship March 30

D

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	3/3/18	3/3/18	0.00	0.00	Start Up Waterjet		SC 18/03/20
100	Waterjet	8 pcs	3/3/18	3/3/18	0.00	0.85	Waterjet1		SC 18/03/20
110	QC	8 pcs	3/3/18	3/3/18	0.00	0.00	QC2 Waterjet-1		SC 18/03/20
120	QC	8 pcs	3/3/18	3/3/18	0.00	0.00	QC8-5		38
130	Brake NC	8 pcs	3/3/18	3/3/18	0.08	0.35	Brake NC 2		9-88 SB
140	Small Fab	8 pcs	3/3/18	3/3/18	0.00	0.44	Small Fab-7		93
150	QC	8 pcs	3/3/18	3/3/18	0.00	0.00	QC5		SA 18-04-02
160	HandFinish	8 pcs	3/3/18	3/3/18	0.00	0.51	HandFinish1		BR 18-4-2
165	QC	8 pcs	3/3/18	3/3/18	0.00	0.00	QC7-4		BR 18-4-2
170	Powdercoat	8 pcs	3/3/18	3/3/18	0.00	0.17	Powdercoat4		BR 18-4-2
180	QC	8 pcs	3/3/18	3/3/18	0.00	0.00	QC3		BR 18-4-2
190	Small Fab	8 pcs	3/5/18	3/5/18	0.00	0.44	Small Fab-7		BR 18-4-2
200	QC	8 pcs	3/5/18	3/5/18	0.00	0.00	QC5		DAS 38
210	Packaging	8 pcs	3/5/18	3/5/18	0.00	0.00	Packaging3-2		APR 02 2018
220	QC21-SA	8 Ea	3/5/18	3/5/18	0.00	0.00	QC21		DAS 21

MB 18-00 START: 10:00 OVT: 320° FINISH: 10:30

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.032	6061-T6 Sheet 0.032"	.5776 sf (.0722 ea)	90-Start up Operation	
MS20426AD3-4	Rivet	32 Ea (4 ea)	190-Small Fab	5018535
MS21059L3	Nut Plate	16 Ea (2 ea)	190-Small Fab	5025740

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.032	1	215	0
190-Small Fab	MS20426AD3-4	32	4,260	0
	MS21059L3	16	199	0

Part Specifications

Specifications could not be found.



DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S054073



Part: D4780-041

Job No: 172986

Serial No/Batch: S054073

Revision:

Inspector:

Date: 03/22/18

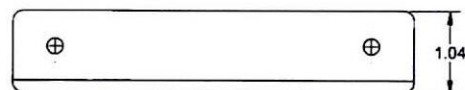
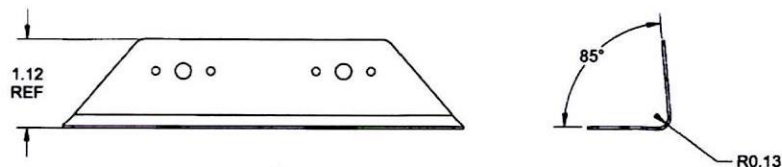
72

FIRST ARTICLE INSPECTION CHECKLIST

QAS
38

by *[Signature]*

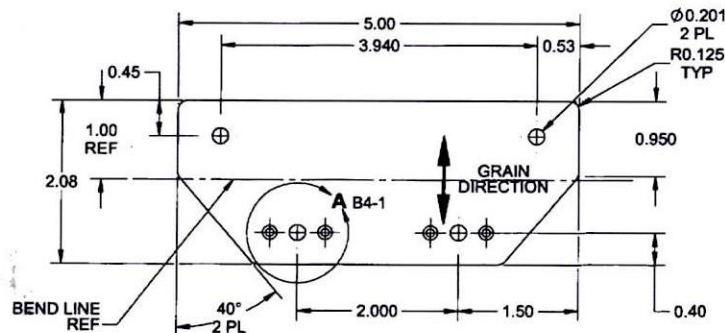
QTY -041	P/N	DESCRIPTION
X	D4780-041	FWD COVER MOUNTING BRACKET ASSY
1	D4780-1	FWD COVER MOUNTING BRACKET
4	MS20426AD3-4	RIVET, CSK
2	MS21059L3	NUTPLATE



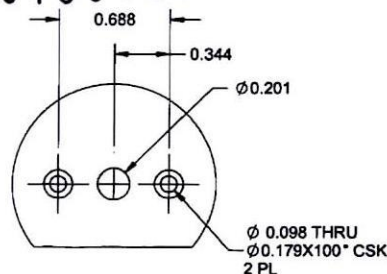
D4780-1 FWD COVER MOUNTING BRACKET
(MAKE FROM D4780-1F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172986 22

20180226



D4780-1F FLAT PATTERN



DETAIL A B7-1
SCALE 2X
2 PL

D4780-1 FWD
COVER MOUNTING BRACKET

MS20426AD3-4 RIVET
2X, 2PL

MS21059L3
NUTPLATE
2 PL

D4780-041 FWD COVER MOUNTING BRACKET ASSY

RELEASED
2013-03-11

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032" THICK, PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF. DART SPEC. M6061T6S.032)
- 2) FINISH: D4780-1F: NONE, D4780-1: CHEMICAL CONVERSION COATING PER DART QSI 005 4.1, POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3, D4780-041: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4780-041" AND B/N USING FINE POINT PERMANENT INK MARKER PER DART QSI 044 METHOD 6.1
- 7) WEIGHT: 0.02 lbs
- 8) PROFILE PER DRAWING FILE "D4780-1F-REVA.DXF"

A	NEW RELEASE	DB	13.03.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	DB		
CHECKED	AB		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.03.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4780** REV. A
SHEET 1 OF 1
TITLE **FWD COVER MOUNTING BRACKET ASSY** SCALE NTS

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